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D4131-043
Job Sheet 193592



Part No: D4131-043

Job Qty: 20 pcs

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 4/26/19

Description:

Type: SOLD

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		4/26/19	0.00	2.25	Waterjet - Flow		04/19/23
120	QC 8	20 pcs		4/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - 2 - B4B	20 pcs		4/26/19	0.00	1.27	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		

150	QC 5	20 pcs	4/26/19	0.00 0.00	Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160	Handfinish - 1-1 Chemical-B4B	20 pcs	4/26/19	0.00 1.14	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	DR19/04/24
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
161	QC 7	20 pcs	4/26/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	

DAS
40
9-89
APR 24 2019

					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	DAS 58 APR 26 2019 9-89
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	DAS 58 APR 26 2019 9-89
165	Small Fab - 2 - B4B	20 pcs	4/26/19	0.00 1.27	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
166	QC 5	20 pcs	4/26/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	APR 25 2019 DAS 40 9-89
180	Packaging 3-1 - Stock - B4B	20 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAE
				Packaging 3 - 36 - B4B	21
190	QC 21 - SA	20	4/26/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

DAE

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Part Op **100** - 1-Cut D4131-7 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr as required
 Descriptions: **120** - QC8- Inspect parts - second check

130 - Small Fab - COUNTER SINK AS PER DWG Deburr if necessary.

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

161 - QC7-Inspect Chemical Conversion Coat

165 - Small Fab - ASSEMBLE NUT PLATES AS PER DWG

166 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	3.6140 sf (.1807 ea)	100-Waterjet - Flow - 1	3055007
MS20426AD3-3	Rivet	160 Ea (8 ea)	165-Small Fab - 2 - B4B	3018535
MS21069L3	Anchor Nut	80 Ea (4 ea)	165-Small Fab - 2 - B4B	5155981

SR312
~~SR312~~
 ST300

SI 58310

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	4	208	0
165-Small Fab - 2 - B4B	MS20426AD3-3	160	1,346	0
	MS21069L3	80	282	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	Diameter	
2	Doubler Assembly	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
3	Doubler Assembly	0.250Inches ± 0.010	0.260 0.240		
4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490		
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395		
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395		
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560		
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630		
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610		
10	Doubler Assembly	4.000Inches ± 0.010	4.010 3.990		
11	Doubler Assembly	4.100Inches ± 0.030	4.130 4.070		
12	Doubler Assembly	4.810Inches ± 0.030	4.840 4.780		
13	Doubler Assembly	4.600Inches ± 0.010	4.610 4.590		
14	Doubler Assembly	5.410Inches ± 0.030	5.440 5.380		
15	Doubler Assembly	0.063Inches ± 0.010	0.073 0.053		

Plex 4/17/19 8:03 AM dart.lacelle.linda



Container No: S174276



Part: D4131 - 043

Job No: 193592

Serial No/Batch: S174276

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 04/23/19